



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5311-041
Job Sheet 202462



Part No: D5311-041

Job Qty: 2 pcs

Part Name: Engine Cowl Swivel Prop Rod Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/12/19

Type: SOLD

Description:

Note: DWG-D5311 REV B IIN REV:A 16.02.10 NEW ISSUE DD VERF:JLM IIN REV:B 16.04.20 ASPER REV:A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	2 pcs	11/12/19	11/12/19	0.00	1.60	Large Fab - 1		MV Nov 8/19
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 5	2 pcs	11/12/19	11/12/19	0.00	0.00	QC 5 - 10		CL
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		



Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL.: 1 613 632-5200
Email: sales@dartae
www.dartaerospace.

Container No: S230117



Part No: D5311-041

Job No: 202462

Serial No/Batch: S230117

Revision: B

Director:

140 Small Fab - 2 - B4B	2 pcs	11/12/19	0.00 0.22	QC 5 - 81	
				Small Fab - 1 - B4B	SMB 19/11/19
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	2 pcs	11/12/19	0.00 0.00	Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Packaging 3-1 - Stock - B4B 2 pcs ✓		11/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	57358
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

Plex 10/28/19 3:19 PM Dart.lajeunesse.marie

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	2 pcs ✓	11/12/19	0.00 0.00	QC 21 - SA - 21 ✓	ST358	
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	9-30	NOV 11 2019

Part Op 110 - (Fabricate per Drwg) 1- WELD SWIVEL JOINTS TO PROP ROD AS PER DWG ***DO NOT GRIND WELDS*** 2-
 Descriptions: INSTALL TWO DOWEL PINS AS PER DWG AND WELD 3- REMOVE WELDING MARKS AS PER NOTE 10 4- INJECT
 WD40 IN HOLES

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Small Fab) INSTALL HEATSHRINK AS PER DWG INSTALL HARDWARE AS PER DWG

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

1*
Grind

012824

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5311-1	Swivel Joint, Inner	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	* P.150545 / F158390
D5311-3	Swivel Joint, Outer	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	F150546
D5311-5	Prop Rod	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	F146913
D5311-7	Prop Rod	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	F165615
D5317-1	Dowel Pin	4 pcs (2 ea)	110-Large Fab - Welded Assy-1	F158090
D3158-030	Heat Shrink	2 pcs (1 ea)	140-Small Fab - 2 - B4B	S159070
D3622-15	Ball Stud	2 pcs (1 ea)	140-Small Fab - 2 - B4B	F151782
LN9016-06K	Washer	2 pcs (1 ea)	140-Small Fab - 2 - B4B	F126527
LN9161-06M	Nut	2 pcs (1 ea)	140-Small Fab - 2 - B4B	S126527

ST019
ST048
ST595
ST565

S16347

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D5311-1	2	10	0
	D5311-3	2	12	0
	D5311-5	2	4	0
	D5311-7	2	4	0
	D5317-1	4	27	0
140-Small Fab - 2 - B4B	D3158-030	2	5	0
	D3622-15	2	14	0
	LN9016-06K	2	21	0
	LN9161-06M	2	18	0

Part Specifications

Specifications could not be found.

Plex 10/28/19 3:19 PM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet ☐ Supplier Quality		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____ ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		_____					